



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2995

Job Sheet 172788



Part No: D2995

Job Qty: 4 ea

Part Name: Bearpaw, 500



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Due Date: 3/2/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV A1 IPP A 01.03.07 New Issue EC IPP Rev:B New Manufacturing Process 08-11-15 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		3/1/18	0.00	0.00	Start Up Waterjet		DC 18/02/28
110	Waterjet	4 pcs		3/1/18	0.00	0.67	Waterjet1		DAS 18/02/28
120	CNC Vertical Machining	4 pcs		3/2/18	0.00	6.82	HAAS1-2		52 18/03/09
130	QC	4 pcs		3/2/18	0.00	0.00	QC2 Machining-1		9.89 18/03/09
140	QC	4 pcs		3/2/18	0.00	0.00	QC8 Machining-1		18/04/11
150	Packaging	4 pcs		3/2/18	0.00	0.00	Packaging3		21
160	QC21-SA	4 Ea		3/2/18	0.00	0.00	QC21		3-00

Part Op 110 - CUT BLANK AS PER FILE D2995

Descriptions: 120 - Inspect material for defects or damage prior to machining Machine as per folio FA119 Deburr

APR 1 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	13.6000 sf (3.4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	14	611	0

Part Specifications

Specifications could not be found.

Plex 2/21/18 4:11 PM Dart.Gagnon.Michelle

DART
AEROSPACE

Uart Aerospace Ltd.
1270 Alardeen Street
Hawthorn, OH K84 1K7
CANADA
Tel: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S045661

Part: D2995

Job No: 172788

Serial No/ Batch: S045661

Revision: D2995

Inspector:

Date: 02/26/18

DART AEROSPACE LTD		Work Order:	
Description: Bearpaw		Part Number:	D2995
Inspection Dwg: D2995 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.625	+/-0.010	.630	✓		Uev	
0.250	+/-0.010	.254	✓		Uev	
R0.25	+/-0.030	R.25	✓		R.G	
0.25 x 45°	+/-0.030 x 0.5°	.250 x 45°	✓		Uev	
5.86	+/-0.030	5.862			Uev	
0.950	+/-0.010	.950			Uev	
0.433	+/-0.010	.440			Uev	
19.00	+/-0.030	19.000			TAPZ	
4.25	+/-0.030	4.25			Uev	
3.63	+/-0.030	3.63			Uev	
7.375	+/-0.010	7.38			Uev	
11.625	+/-0.010	11.625			TAPZ	
0.38	+/-0.030	.380			Uev	
3.081	+/-0.010	3.083			Uev	
17.73	+/-0.030	17.730			TAPZ	
19.34	+/-0.030	19.340			TAPZ	
Ø0.260	+0.006/-0.001	.260	✓		G.Pi	
0.30	+0.030/-0.000	0.308	✓		D.G.	
Ø0.93	+/-0.030	.931	✓		Uev	

DAS
52

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 18/03/09	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.02	New Issue	KJ/JLM	
B	09.05.19	Tolerances revised	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

 QA Closed: **DAS 53**
 9-89

Date: MAY 29 2018

Work Order update only ☐

Work Order: <u>172788</u> Part No. <u>02995</u> NCR No. <u>18-6878</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☒	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																																
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